18

DART AEROSPACE LTD	Work Order:	19081
Description: Spacepod Hardware Kit	Part Number:	K10018
Dwg: D2174-1 Rev. C; D2174-041 Rev. C; D2175 Rev. C	Qty:	1 Kits
		Page 1 of 2

RF 03.04.30

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required. **Note: K10018 Kit to be made in multiples of 7.** **(1) K10018 requires (2) D2174-041.** **(1) D2174-041 consists of (1) D2174-1 Web & (2) D2175 Angle**	KJ	03.04.30	1
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) **Use stack of 7** **Identify for D2174-1** Batch: _____			
3	MV	**Cut (2) blanks per (1) K10018 Kit** Cut blanks: (12.200" x 2.960") **grain along 2.960** Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) **Use stack of 7** **Identify for D2175** Batch: _____			
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 **Identify as D2174-1**			
5	QC2	Inspect parts as they come off the CNC machine			
6	MV	Deburr for measurement			
7	QC8	Second check			01
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 **Identify as D2175**		03-04-05	
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr for measurement			
11	QC8	Second check			
12	GA	Deburr D2174-1 and D2175 stacks			
13	GB	Form D2175 Angle as per Dwg D2175			
14	QC5	Inspect work to Step 13			
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175			
16	QC3	Inspect work to Step 15			
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 **Pick:** Qty Part Number Description Batch 23 MS20470AD4-6 Rivet _____ **Identify as D2174-041**			
18	QC5	Inspect work to Step 17			
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3			
20	QC3	Inspect Powder Coat. Go to KP cell for packing.			

RELEASED 03.04.30 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Manuf / Design Mgr	**Approval** QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	**STEP**	**Description of NC** section A	**Intial**	**Corrective Action** Section B	**Sign & Date**	**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector

PAR#:_____ Fault Category:_____ DQA:_____ Date:_____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date:_____

DART AEROSPACE LTD	Work Order:	19081
Description: Spacepod Hardware Kit	Part Number:	K10018
Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C	Qty:	1 Kits
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty
21	KP	**Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 & 3)** Qty / Part Number / Description / Batch 2 D2174-041 Web Assembly B116502 1 D2985 Decal B12773 8 A3235-020-935 Washer M11217 16 AKS#-1032-130 Insert M16087 8 AN3-3A Bolt M3155 8 AN3H4A Bolt (or AN3H4) M12493 36 AN525-10R7 Screw M11822 8 AN960JD10 Washer M13063 16 AN960JD10L Washer M11670 16 MS21042L3 Nut (or –3) M12241 8 MS24694S67 Screw M3100 1 D2584 Keys B14055 installed on pod 03.05.01	1 03-04-30	03.05.01	1
22	QC4	Inspect Kit 100% for Completeness on the W/O		03.05.01	1
23	ST	Identify and Stock		03-05-01	1
24	AC	Cost / part 63.92	SAC	03-05-02	1
25	DC	Close W/O 63.92 Inspect Level 21		03.05.01	—

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF RF	

RELEASED
03.04.30 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Manuf / Design Mgr	**Approval** QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	**STEP**	**Description of NC** section A	**Intial**	**Corrective Action** Section B	**Sign & Date**	**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector

PAR#:_____ Fault Category:_____ DQA:_____ Date:_____

QA: N/C Closed: _____ Date:_____

NOTE: Date & initial all entries

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 30, 2003
08:19 am

Work Order No	: 0019081		
Project Name	: K10018	Department Code	:
Project For	: WK18	Burden Flags	: NNNNNNN
Work Order Type	: Main	WO Status	: Open
Main WO Number	:	Invoice State	: Not Invoiced
House Part Number	: K10018	Invoice Date	:
Description	: Spacepod Hardware Kit	Invoice Number	:
Manufactured	: Yes	Invoice Amount	: 0.00
Amount Req'd	: 1		
Amount Done	: 0	Order Entry No	:
Start Date	: 04-30-03	OE Value	: 0.00
Est Finish Date	: 04-30-03		
Act Finish Date	:	Est Margin	: 0.000%
Drawings Reqd	: No	Actual Margin	: 0.000%
Ok for Approval	:		
Approval Rec'd	:	$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00